

Work Order ID 53830

November 19, 2009 8:39:47 AM



Beaup

Page 1

Item ID: D4013-11

Accept



Setup Start



Revision ID:

Item Name: Stud

Stop



Start Date: 11/19/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 11/23/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: *ME*

Date: *09-11-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4013

C

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

turn as per Dwg and Folio FA861

Folio Rev: *2/1*

Dwg Rev: *C*

Deburr

0.00

SA 09/11/21

40 *✓*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

SA 09/11/21

40 *✓*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53830

November 19, 2009 8:39:47 AM



Page 2

Item ID: D4013-11

Accept



Setup Start



Revision ID:

Item Name: Stud

Stop



Start Date: 11/19/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 11/23/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00				40	0		
Quality Control									
130	Identify as per dwg & Stock Location: <i>W/A</i>	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Q 9-11-23 *(X40)*

09/11/24 *(Signature)*
MF 09-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 19, 2009 8:39:47 AM

Page 1

Work Order ID: 53830



Parent Item: D4013-11



Parent Item Name: Stud

Start Date: 11/19/2009

Required Date: 11/23/2009

Comments: IPP REV:A NEW ISSUE 09-11-03 JLM VERIFIED BY:DD IPP
RevB: revC as per dwg 09.11.18 DD verified by:JLM

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304RO.750		Purchased	No			100	f	14.2300	6.3158			
304 SS Roundbar .750												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	14.23
109421	1.39
110166	1.44
110912	6.06
111323	3.5
111988	1.84

113216

6.4 ft SA 03/11/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

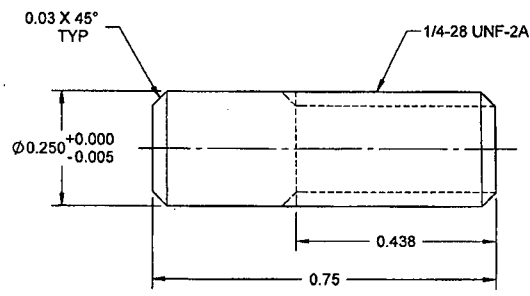
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

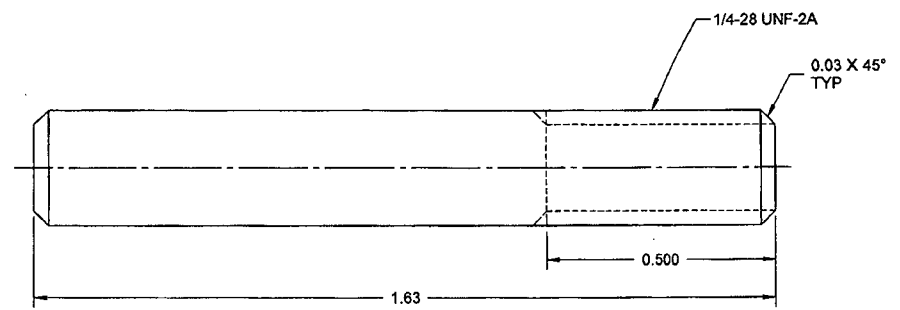
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

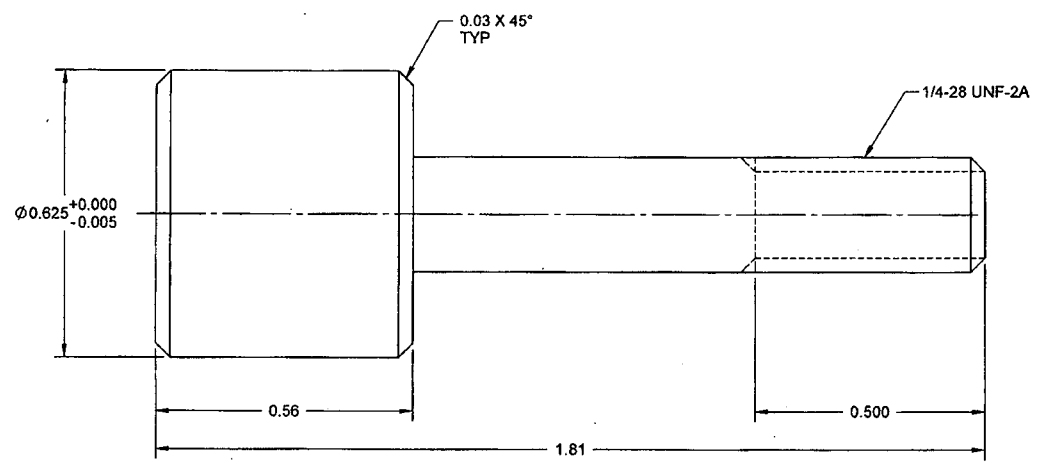
8 7 6 5 4 3 2 1



D4013-3 STUD



D4013-9 STUD



D4013-11 STUD

#53830

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: LESS THAN 0.01 lbs EACH

DESIGN	11	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D4013	REV. C
MFG. APPR.	DS	SHEET 4 OF 5	
APPROVED	MS	TITLE WEARPLATE ASSEMBLY	SCALE
DE APPR.	MS	NTS	
DATE	09.11.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CAPTIONED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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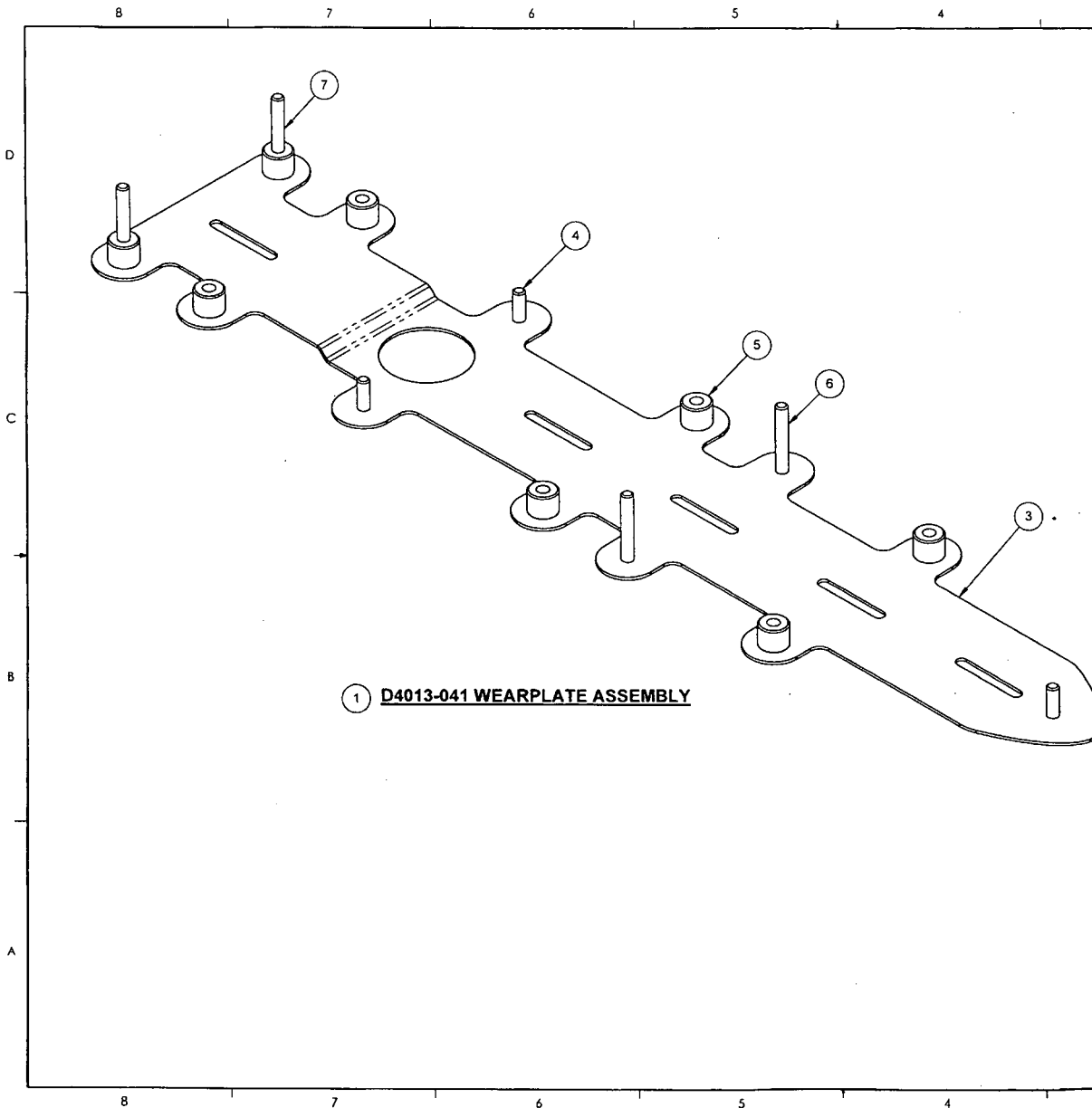
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



① D4013-041 WEARPLATE ASSEMBLY

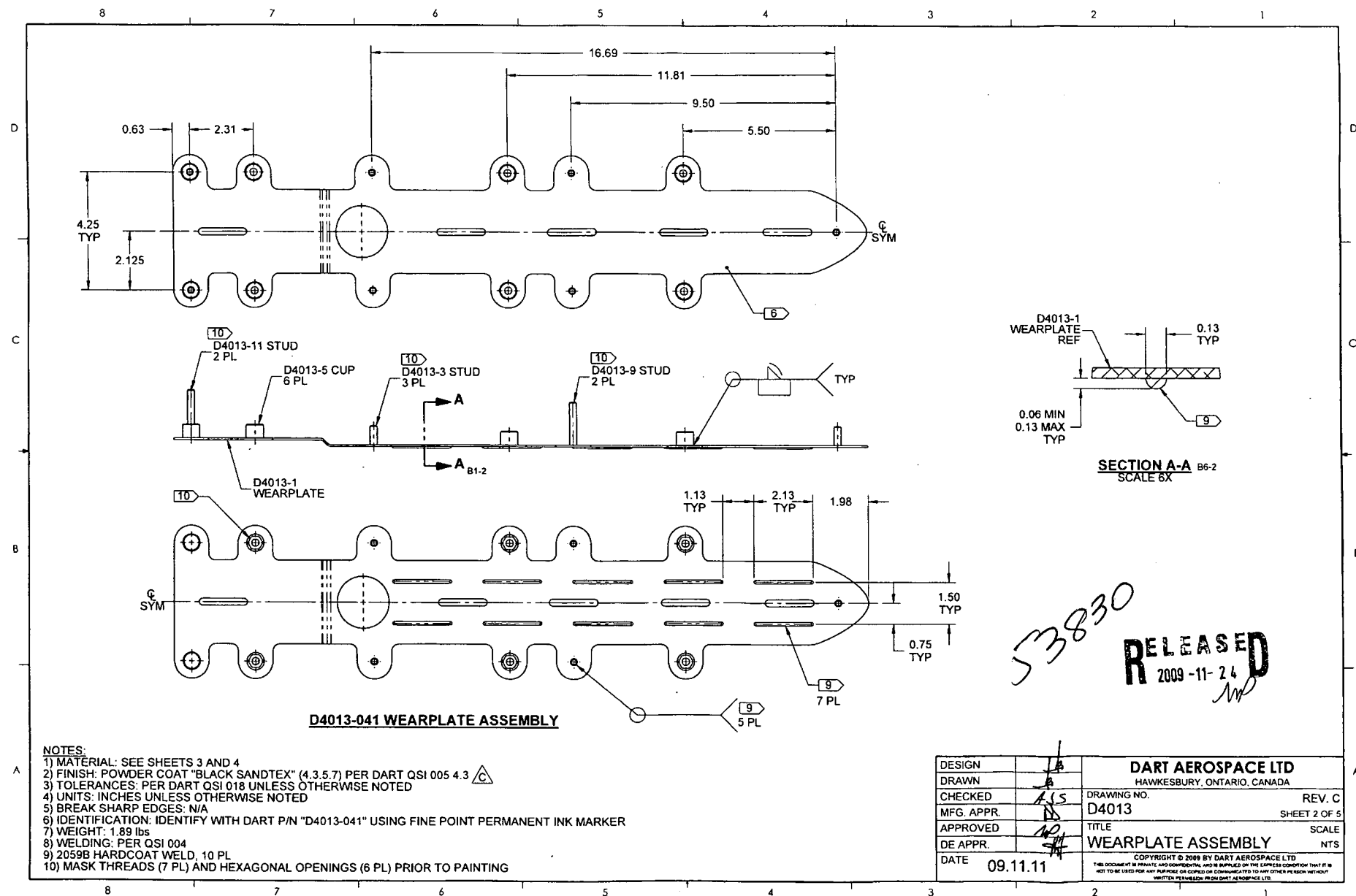
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1	X	D4013-041	WEARPLATE ASSEMBLY
3	1	D4013-1	WEARPLATE
4	3	D4013-3	STUD
5	6	D4013-5	CUP
6	2	D4013-9	STUD
7	2	D4013-11	STUD
21	A/R	2059B	HARDCOAT

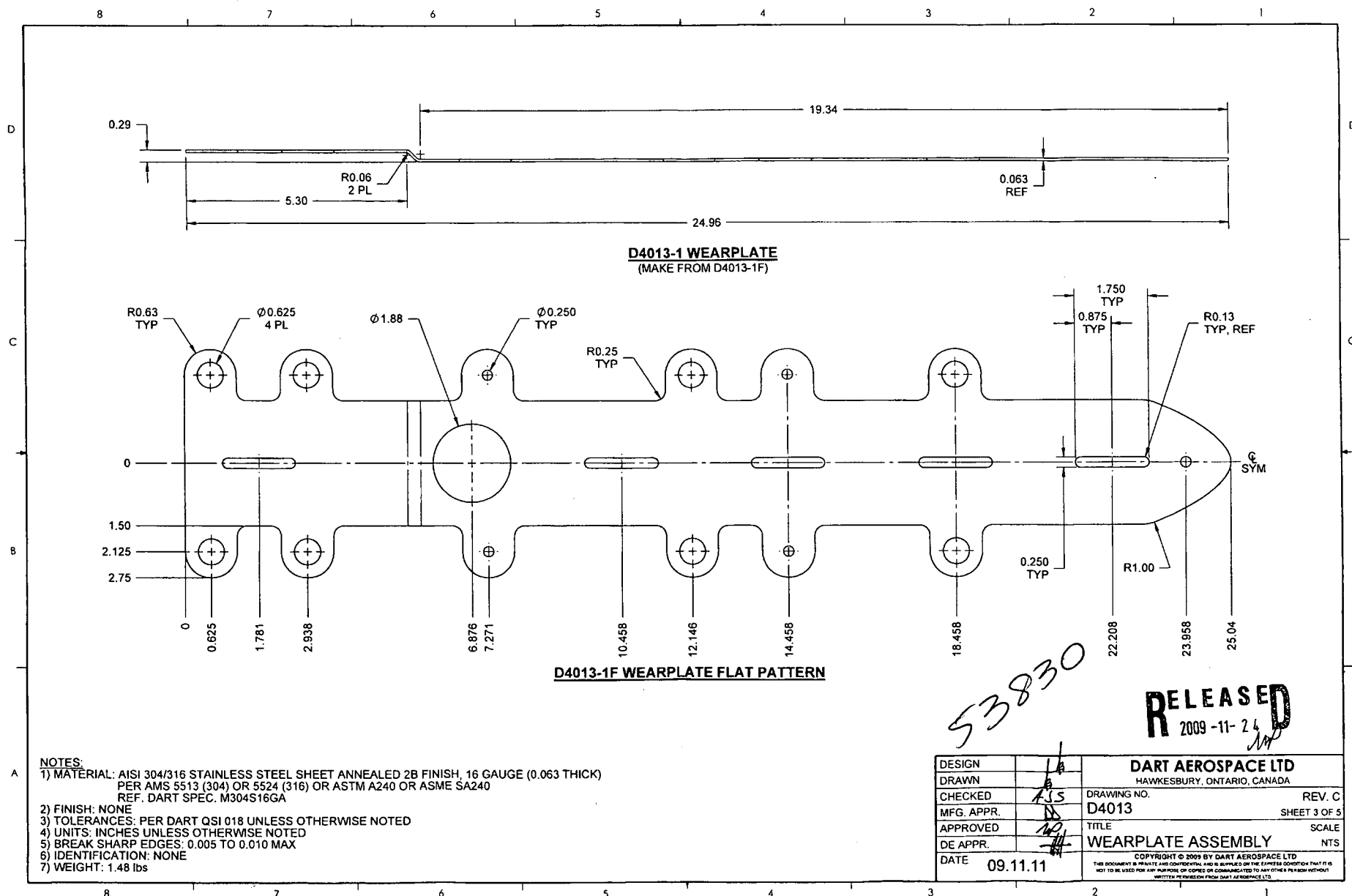
C	SIMPLIFY DESIGN FOR MANUFACTURING PURPOSES; REDESIGNED ITEM 5; ELIMINATED D4013-7 CUP (NO LONGER USED); CHANGED FINISH FROM GREY TO BLACK SANDTEX		MB	09.11.11
B	REDESIGN		MB	09.11.02
A	NEW ISSUE		MB	09.10.22
REV.	DESCRIPTION	BY	DATE	
DESIGN	LA			
DRAWN	AS			
CHECKED	AS			
MFG. APPR.	AS			
APPROVED	AS			
DE APPR.	AS			
DATE	09.11.11			

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2009-11-24
MP

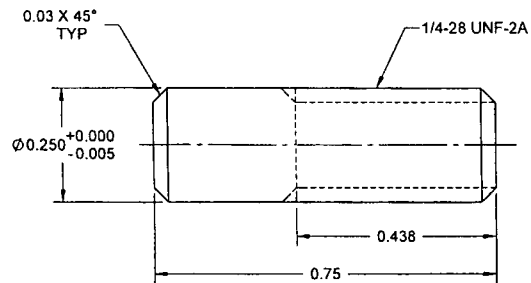
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D4013
TITLE WEARPLATE ASSEMBLY
REV. C
SHEET 1 OF 5
SCALE NTS

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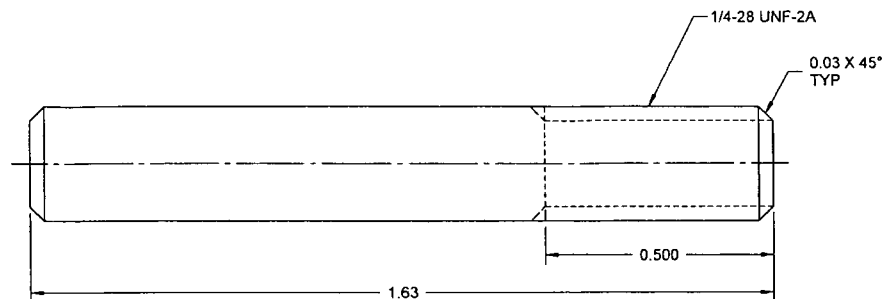




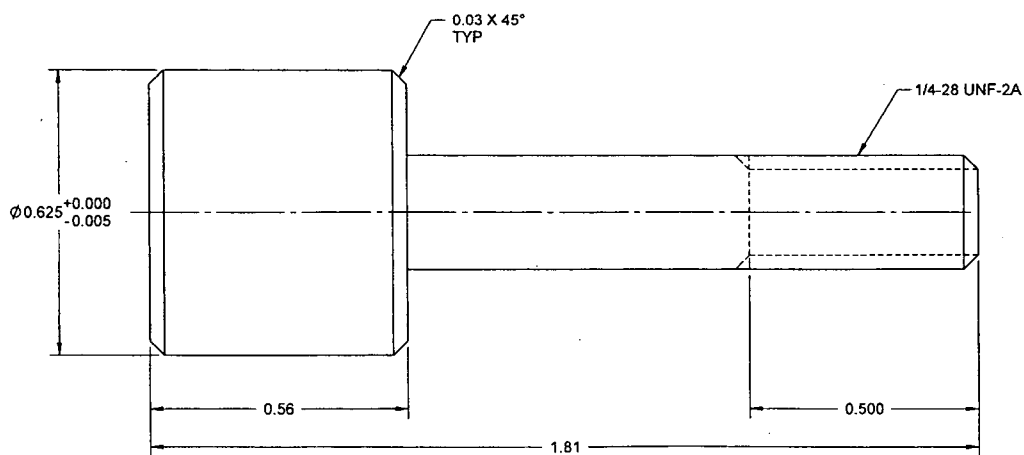
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D4013-3 STUD



D4013-9 STUD



D4013-11 STUD

NOTES:

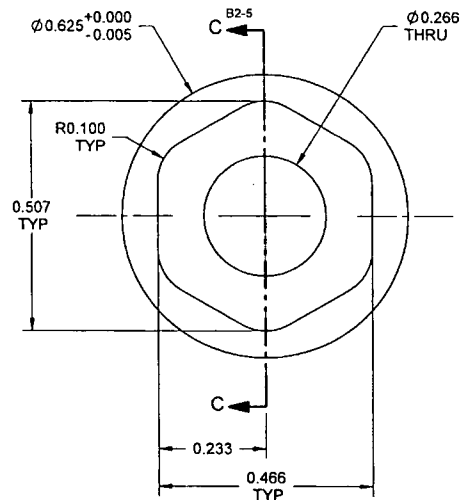
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: LESS THAN 0.01 lbs EACH

53830

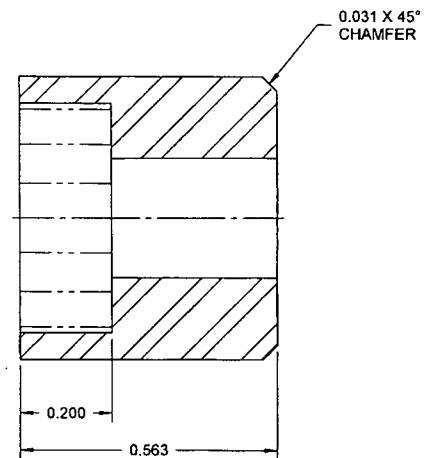
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CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	B	D4013	SHEET 4 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.	11	WEARPLATE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D4013-5 CUP



SECTION C-C D6-5

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs EACH

DESIGN	LB	DART AEROSPACE LTD	
DRAWN	LB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	DS	D4013	SHEET 5 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	SH	WEARPLATE ASSEMBLY	
DATE	09.11.11	NTS	

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53830